

Date: Tuesday, 5/23/2006 8:11:03 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 27159A	Part Number	: D2221		
Estimate Number	: 10189	Drawing Number	: D2221/D2235		
P.O. Number	: N/A	Project Number	: N/A		
This Issue	: 5/23/2006	S.O. No.	: N/A		
Prsht Rev.	: NC	Type	: LARGE FAB ASSY		
First Issue	: N/A	Material	: N/A		
Previous Run	: 27049A	Due Date	: 5/30/2006		
Written By	: <i>Serg Comment Below</i>			Qty:	1
Checked & Approved By	: <i>Jf Ob. 05.23</i>			Um:	Each
Comment	: Est Rev:J 05.09.02 Added D3442-1KJ/JLM				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D31661	Basket Hoop		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D3166-1 RIB <i>B26717</i>	PD	<i>Ob05-19</i>
2.0	D22323	Basket Hinge		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2232-3 Hinge bracket <i>B24527</i>	PD	<i>Ob05-23</i>
3.0	D2325	Support Gusset (350 Bask)		
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		4 D2325 Support Gusset <i>B26922</i>	PD	<i>Ob05-23</i>
4.0	D23273	Spacer Bushing		
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)		
		Pick:		
		Qty Part Number Description Batch		
		2 D2327-3 Bushing <i>B25823</i>	PD	<i>Ob05-23</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 8:11:04 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27159A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B26204

PD

06-05-23

6.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B26239

PD

06-05-23

7.0 M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total : 39.6900 sf(s)

Pick:

Qty Part Number Description Batch

36 sf M304EX0.75-16F Expanded Metal H100981

PD

06-05-24

8.0 M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch:M100745

PD

06-05-29

9.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes

 NoDQA: Date: 06/06/07

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Date: Tuesday, 5/23/2006 8:11:04 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 27159A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

10/06/05/26

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

10. m 06-05-30

(1)

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10/06-31 (1)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: M100901

SAD 06:05:31

(1)

Expiry date: 11/2006

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

10/06-07 (1)

Job Completion



u dard

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)		SCALE NTS

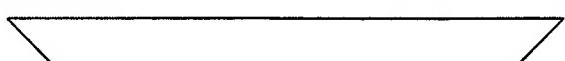
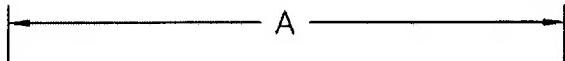
RELEASED

05.08.19 *[initials]*

C	95.11.21	SEPARATE BASKET AND LID
D	96.06.21	CHANGE LATCH
E	01.04.19	CHANGE HINGE
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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45:  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27159A

D2221-1/-3/-5/-7

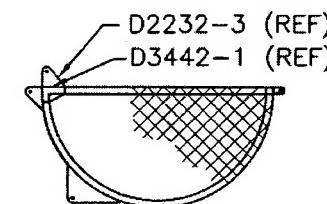
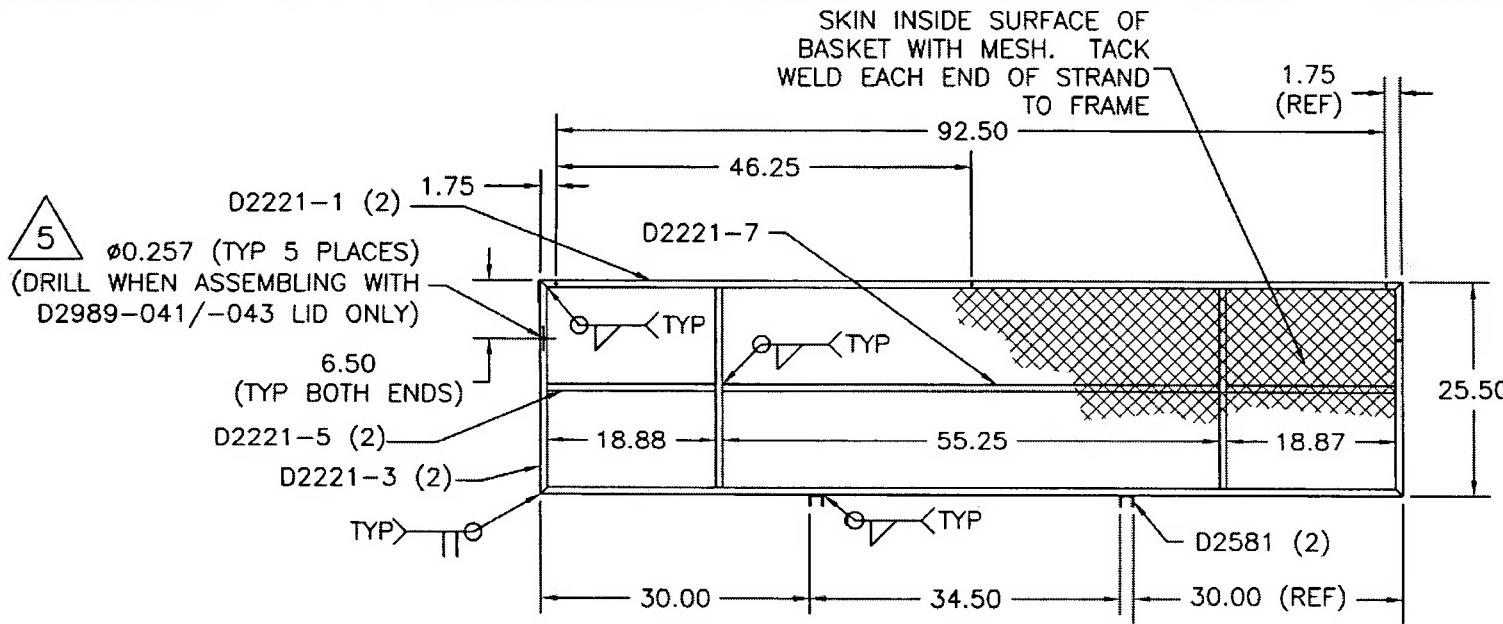
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL Ø0.257 HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH D2989-041/-043 BASKET LID

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DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221
DATE 05.06.07	TITLE BASKET BASE ASSEMBLY (350)	REV. F SHEET 2 OF 3 SCALE 1:20



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WITHOUT NOTICE  
WORK ORDER  
NO. 27159A

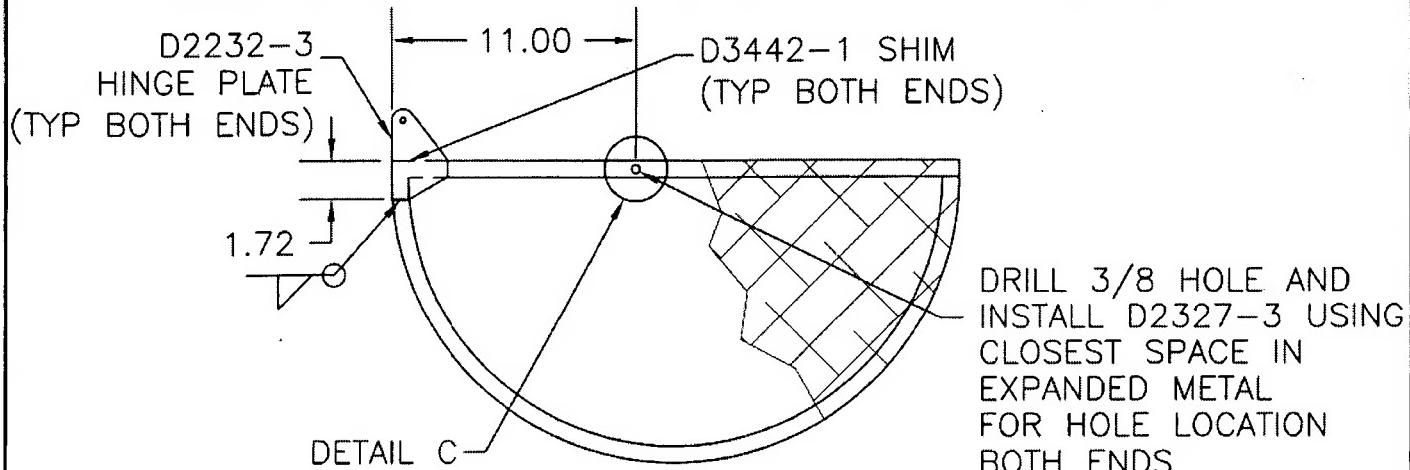
325 RETURN TO  
ENGINEERING  
RELEASED  
05.08.19 *[initials]*

#### D2221 BASKET BASE ASSEMBLY

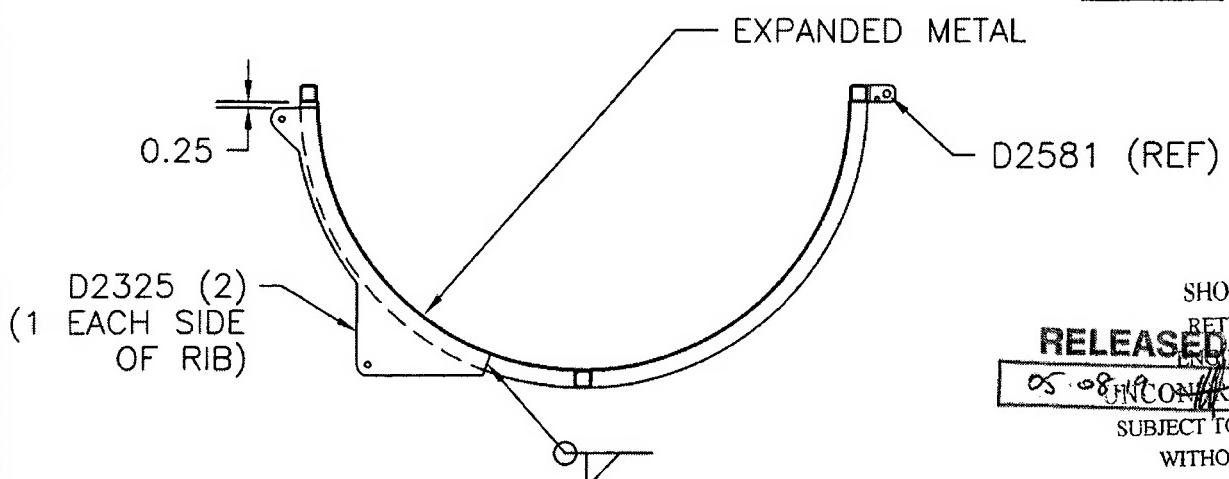
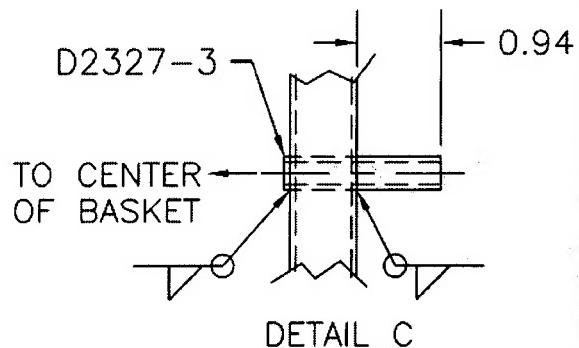
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2221	REV. F SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS



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WITHOUT NOTICE  
WORK ORDER  
NO. 27159A

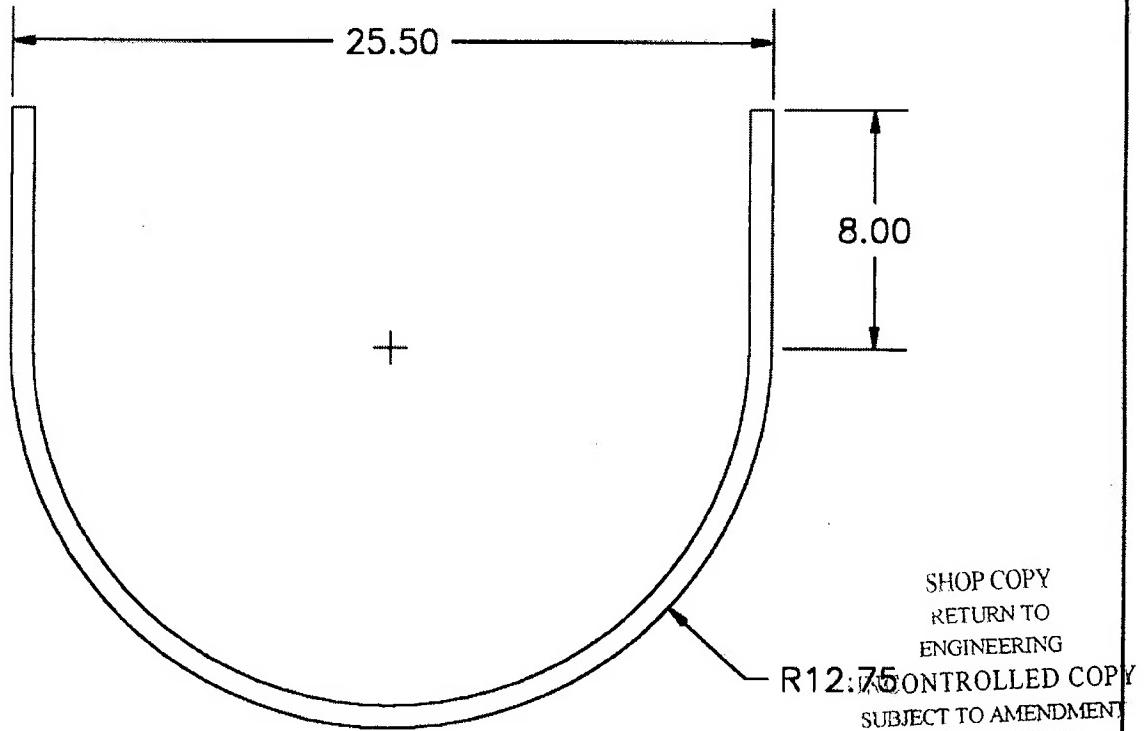
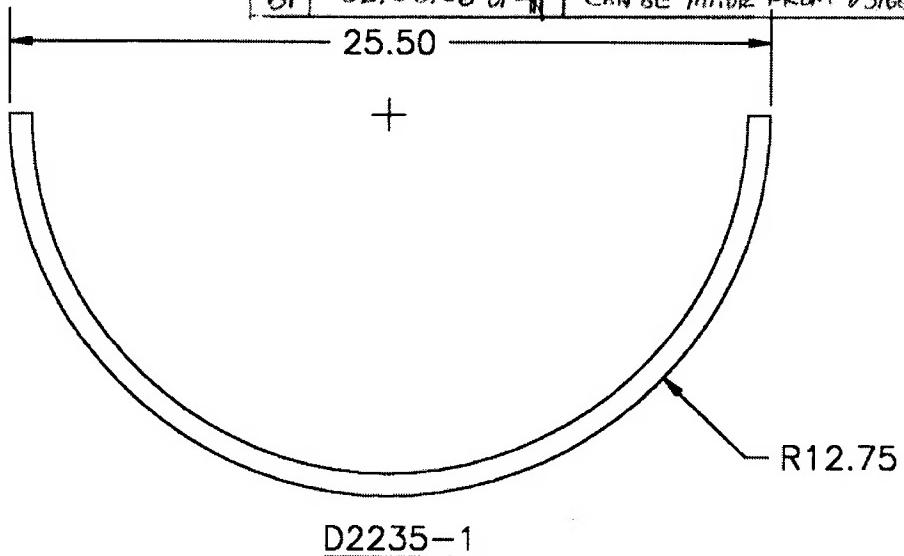
SECTION B-B SAME BOTH CENTER RIBS

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**DART**

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235
DATE 94:12:16		TITLE SCALE BASKET RIBS

REV. B  
SHEET 1 OF 1BI 02.08.06 ~~07~~ CAN BE MADE FROM D3166-1**RELEASED**  
R 960507CAN BE MADE FROM D3166-1 BI  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.